



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3282-041
Job Sheet 203175



Part No: D3282-041

Job Qty: 4 pcs

Part Name: Float Web (206L/407)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/11/19

Job Tracking No:

Due Date: 12/6/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV D IPP Rev:B 05.09.23 Procedure change KJ/JLM IPP REV:C 11.09.20 remove LPS as per dwg
revD DD verf:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Skidtubes - 1	4 pcs	12/6/19		0.00	0.67	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4	TF	
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
110	HAAS 4 Axis - B4B	4 pcs	12/6/19		0.31	6.56	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
130	QC 8	4 pcs	12/6/19		0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		



Container No: S232180



Part: D3282-041

Job No: 203175

Serial No/Batch: S232180

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 11/15/19

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140 Handfinish - 1-1 Chemical-B4B	4 pcs	12/6/19	0.00 0.93	QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	DAS
				QC 8 - 23	23
				QC 8 - 57	9-89
				QC 8 - 76	
				QC 8 - 61	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
150 QC 7	4 pcs	12/6/19	0.00 0.00	Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
				QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	

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					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	MBL
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
					QC 7 - 76	
					QC 7 - 79	
160 Skidtubes - 2 - B4B	4 pcs	12/6/19	0.00 3.50		Skidtubes - 1 - B4B	
					Skidtubes - 2 - B4B	
					Skidtubes - 3 - B4B	
					Skidtubes - 4 - B4B	
					Skidtubes - 5 - B4B	BE
					Skidtubes - 6 - B4B	
					Skidtubes - 7 - B4B	
170 QC 5	4 pcs	12/6/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	BE
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
180 Packaging 3-1 - Stock - B4B	4 pcs	12/6/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	

				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	MLC
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAE
190 QC 21 - SA	4	12/6/19	0.00 0.00	QC 21 - SA - 21	21
	pcs			QC 21 - SA - 70	LM
				QC 21 - SA - 53	

FEB 05 2020

Part Op 100 - (Skidtubes) 1-Cut to length as per Dwg D3282. 2- inspect for surface damage as per QSI0018
 Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine as per Folio FA579 & Dwg D3282 2-Deburr
 130 - (QC8- Inspect parts - second check)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (QC7-Inspect Chemical Conversion Coat)
 160 - (Skidtubes) 1-Install doublers as per Dwg D3282.
 170 - (QC5- Inspect part completeness to step on W/O)
 180 - (Identify as per dwg & Stock Location: LG002) LOCATION : LG002
 190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2792-130	Extrusion	4 pcs (1 ea)	100-Skidtubes - 1	B128109
D3283-1	Doubler	8 pcs (2 ea)	160-Skidtubes - 2 - B4B	S210759
MS20470AD4-7	RIVET	228 Ea (57 ea)	160-Skidtubes - 2 - B4B	S225698

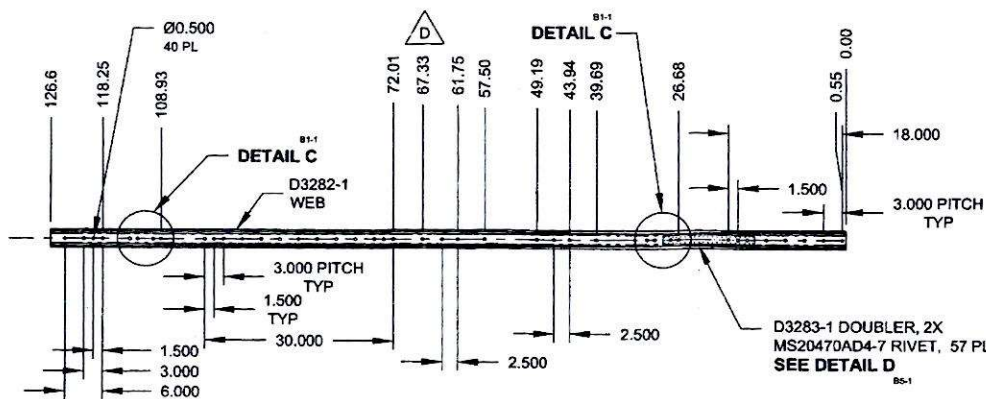
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Skidtubes - 1	D2792-130	4	24	0
160-Skidtubes - 2 - B4B	D3283-1	8	38	0
	MS20470AD4-7	228	2,538	0

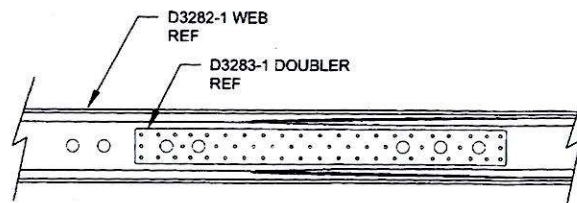
Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Float Web	126.600inches $\pm$ 0.010	126.610 126.590		
2	Float Web	1.500inches $\pm$ 0.010	1.510 1.490		
3	Float Web	3.000inches $\pm$ 0.010	3.010 2.990		
4	Float Web	6.000inches $\pm$ 0.010	6.010 5.990		
5	Float Web	1.250inches $\pm$ 0.010	1.260 1.240		
6	Float Web	30.000inches $\pm$ 0.010	30.010 29.990		
7	Float Web	1.500inches $\pm$ 0.010	1.510 1.490		
8	Float Web	72.010inches $\pm$ 0.030	72.040 71.980		
9	Float Web	61.750inches $\pm$ 0.030	61.780 61.720		
10	Float Web	57.500inches $\pm$ 0.030	57.530 57.470		
11	Float Web	49.190inches $\pm$ 0.030	49.220 49.160		
12	Float Web	43.940inches $\pm$ 0.030	43.970 43.910		
13	Float Web	39.690inches $\pm$ 0.030	39.720 39.660		
14	Float Web	26.680inches $\pm$ 0.030	26.710 26.650		
15	Float Web	0.550inches $\pm$ 0.030	0.580 0.520		
16	Float Web	1.970inches $\pm$ 0.010	1.980 1.960		
17	Float Web	2.380inches $\pm$ 0.030	2.410 2.350		
18	Float Web	0.050inches $\pm$ 0.030	0.080 0.020		

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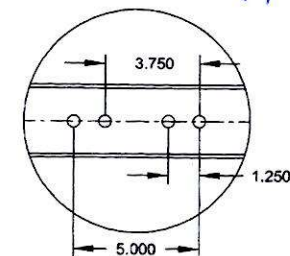
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 203175 MLC
1971-11



D3282-041 WEB



DETAIL D



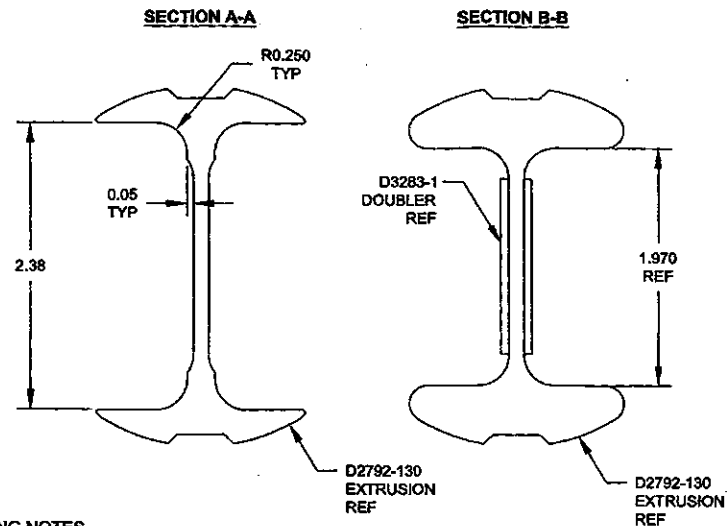
DETAIL C

NOTE: RIVET HOLES/DOUBLER
NOT SHOWN FOR CLARITY

RELEASED
2011-09-12

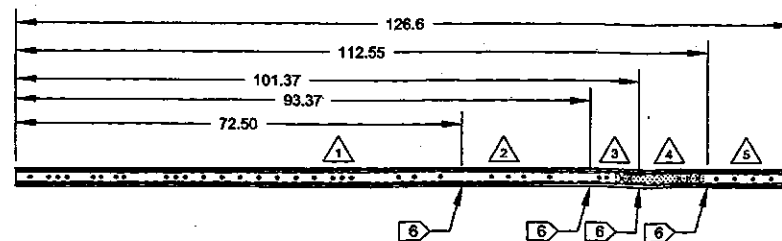
- NOTES:
- 1) MAKE D3282-1 WEB FROM D2792-130 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 6) IDENTIFICATION: IDENTIFY WITH P/N "D3282-041" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
 - 7) WEIGHT: 20.0 lbs
 - 8) SEE PAGE 2 FOR MACHINING DETAILS

D	ADD ADDITIONAL HOLE (ZN D6-1); REMOVE LPS-3 (ZN C3-1)	SC	11.05.05
C	REMOVE D3390-1, NOW MACHINED	CP	05.08.09
B	MOVE HOLES, ADD D3390-1 DOUBLERS	CP	05.03.16
A	NEW ISSUE	CP	04.05.05
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	SC		
CHECKED	90	DRAWING NO.	REV. D
MFG. APPR.	90	D3282	SHEET 1 OF 2
APPROVED	90	TITLE	SCALE
DE APPR.	90	WEB	NTS
DATE	11.05.05	COPYRIGHT © 2004 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D3282-1 MACHINING NOTES

- 1 UNIFORM SECTION A-A
- 2 UNIFORM TAPER FROM SECTION A-A TO SECTION B-B
- 3 UNIFORM SECTION B-B
- 4 UNIFORM TAPER FROM SECTION B-B TO SECTION A-A
- 4 DRILL #30 (Ø0.128 REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1, SEE DETAIL D FOR REFERENCE
- 5 UNIFORM SECTION A-A
- 6 R1.00 BETWEEN SECTIONS



RELEASED
R 2011-09-12

DESIGN	CP	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D3282	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEB	NTS
DATE	11.05.05	COPYRIGHT © 2004 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE EXPRESS PERMISSION FROM DART AEROSPACE USA, INC.	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					

DART AEROSPACE LTD		Work Order: 203175
Description: Float Web		Part Number: D3282-041
Inspection Dwg: D3282	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
126.6	+/-0.100	126.600	✓		tape	(REF)
1.500	+/-0.010	1.497	✓		vernier	B17321453
3.000	+/-0.010	2.995	✓		Vernier	B17321453
6.000	+/-0.010	5.993	✓		Vernier	B17321453
1.250	+/-0.010	1.247	✓		Vernier	B17321453
30.000	+/-0.010	30.000	✓		tape	(REF)
1.500	+/-0.010	1.492	✓		vernier	B17321453
72.01	+/-0.030	72.00	✓		tape	(REF)
61.75	+/-0.030	61.750	✓		" "	(REF)
57.50	+/-0.030	57.500	✓		" "	(REF)
49.19	+/-0.030	49.187	✓		" "	(REF)
43.94	+/-0.030	43.950	✓		" "	(REF)
39.69	+/-0.030	39.687	✓		" "	(REF)
26.68	+/-0.030	26.687	✓		tape	(REF)
0.55	+/-0.030	0.546	✓		Vernier	B17321453
1.970	+/-0.010	1.968	✓		Vernier	B17321453
2.38	+/-0.030	2.375	✓		Vernier	B17321453
0.05	+/-0.030	0.049	✓		Vernier	B17321453

Measured by: MM. 64	Audited by: [Signature]	Preliminary Approval:
Date: 2020/01/15	Date: 2020/11/17	Date:

Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM	
B	12.02.01	Dwg Rev updated	KJ	

1296

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